Date.

Monday, 1/7/2008 3:38:41 PM

User:

Kim Johnston

**Process Sheet** 

Customer

: CU-DAR001 Dart Helicopters Services

: 36636

Job Number **Estimate Number** 

: 12719

P.O. Number This Issue

**Previous Run** 

Written By

Prsht Rev. First Issue

Checked & Approved By

: SMALL /MED FAB

New Issue 07-02-14 JLM

Project Number **Drawing Revision** Material

**Drawing Number** 

**Drawing Name** 

**Part Number** 

Due Date

: D353625

: GASKET

· D3536 REV A

: N/A

: 1/21/2008

Qty:

20 Um:

Each

Comment Additional Product

Job Number:



Seq. #:

Machine Or Operation:

: Est Rev:A

Description:

NEOPRENE SHEET 0.063

1.0

MNEO60S063



Comment: Qty.: 0.6254 sf(s)/Unit 16.2604

Total: 12.5076 sf(s)

**NEOPRENE SHEET 0.063** 

Batch:

20

WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3536

Dwg Rev:\_ Prog Rev:\_ B 8-1-9



2-Deburr if necessary

3.0

QC2

HB 8-1-9

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

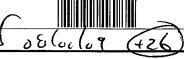
QC8

SECOND CHECK



Comment: SECOND CHECK

PACKAGING 1



5.0

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

8/1/9 50

| Dart A | \erosp | ace l | Ltd |
|--------|--------|-------|-----|
|--------|--------|-------|-----|

| W/O:    |      |     | WORK ORDER (           | CHANGES  |        |        |                                     |                          |
|---------|------|-----|------------------------|----------|--------|--------|-------------------------------------|--------------------------|
| DATE    | STEP | i i | PROCEDURE CHANGE       | Ву       | Date   | Qty    | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|         |      | !   |                        |          |        |        |                                     |                          |
|         |      | l   |                        |          |        |        |                                     |                          |
|         |      | !   |                        |          |        |        |                                     |                          |
|         |      | i   |                        |          |        |        |                                     |                          |
| Part No | ):   |     | PAR #: Fault Category: | NCR: Yes | No) DQ | A: _\_ | Date: <u>C</u>                      | <u> </u>                 |

|      |      | ļ     | !            |                      |                              | QA: N/C        | C Closed:    | _ Date: _             |                          |
|------|------|-------|--------------|----------------------|------------------------------|----------------|--------------|-----------------------|--------------------------|
| NCR: |      | ı     | 1            | WORK OR              | DER NON-CONFORMANC           | E (NCR)        |              |                       |                          |
|      |      | Dosor | iption of NC |                      | Corrective Action Section B  |                | Verification | Annroyal              | Approval                 |
| DATE | STEP |       | Section A    | Initial<br>Chief Eng | Action Description Chief Eng | Sign &<br>Date | Section C    | Approval<br>Chief Eng | Approval<br>QC inspector |
|      |      | i     |              | 1                    |                              |                |              |                       |                          |
|      |      |       |              |                      |                              |                |              |                       |                          |
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|      |      |       |              |                      |                              |                |              | •                     |                          |

NOTE: Date & initial all entries

Date:

Monday, 1/7/2008 3:38:41 PM

User:

Kim Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 36636

Part Number: D353625

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



zeosililio

# Dart Aerospace Ltd

| W/O:    |      |   |        | WORK ORDER      | CHANGES |        |            |     | ···                           |                          |
|---------|------|---|--------|-----------------|---------|--------|------------|-----|-------------------------------|--------------------------|
| DATE    | STEP |   | PR     | OCEDURE CHANGE  |         | Ву     | Date       | Qty | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |
|         |      |   | -      |                 |         |        |            |     | Ì                             |                          |
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|         |      |   |        |                 |         |        |            |     |                               |                          |
| Part No | •    |   | PAR #: | Fault Category: | NCI     | R: Yes | No DQ      | ٨:  | Date:                         |                          |
|         |      |   |        |                 |         | QA:    | N/C Closed | l:  | _ Date:                       |                          |
|         |      |   |        |                 |         |        |            |     |                               |                          |

| NCR: |      |                   | WORK ORD             | ER NON-CONFORMANO            | CE (NCR)       |              | ;         |             |
|------|------|-------------------|----------------------|------------------------------|----------------|--------------|-----------|-------------|
|      |      | Description of NC |                      | Corrective Action Section B  |                | Verification | Approval  | Approval    |
| DATE | STEP | Section A         | Initial<br>Chief Eng | Action Description Chief Eng | Sign &<br>Date | Section C    | Chief Eng | QC Inspecto |
|      |      |                   |                      |                              |                |              |           |             |
|      |      | :                 |                      |                              |                |              |           |             |
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|      |      |                   |                      |                              |                |              |           |             |

NOTE: Date & initial all entries

| DART AEROSPACE LTD           | Work Order:  | 36636       |
|------------------------------|--------------|-------------|
| Description: Gasket          | Part Number: | D3536-25    |
| Inspection Dwg: D3536 Rev: A |              | Page 1 of 1 |

## FIRST ARTICLE INSPECTION CHECKLIST

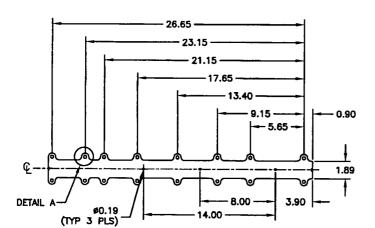
| X First | Article | Prototype |
|---------|---------|-----------|
|---------|---------|-----------|

| Drawing<br>Dimension | Tolerance     | Actual Dimension | Accept   | Reject                    | Method of<br>Inspection | Comments |
|----------------------|---------------|------------------|----------|---------------------------|-------------------------|----------|
| 21.80                | +/-0.030      | 08.16            |          |                           |                         |          |
| 16.35                | +/-0.030      | 16.35            |          |                           |                         |          |
| 10.90                | +/-0.030      | 09.01            |          |                           |                         |          |
| 5.45                 | +/-0.030      | 5,44             |          |                           |                         |          |
| 6.00                 | +/-0.030      | 6.00             | ×        |                           |                         |          |
| 6.75                 | +/-0.030      | 6.75             | æ        |                           |                         |          |
| 12.75                | +/-0.030      | 12.75            | 7        |                           |                         |          |
| 1.89                 | +/-0.030      | 1.896            | ×        |                           |                         |          |
| 0.30                 | +/-0.030      | .30              | ×        |                           |                         |          |
| 0.30                 | +/-0.030      | 130              | 8        |                           |                         |          |
| Ø0.19                | +0.005/-0.001 | .189             | *        |                           |                         |          |
|                      |               |                  |          |                           |                         |          |
|                      |               |                  |          |                           |                         |          |
| Measured by:         | LB.           | Audited by:      | <u>d</u> | $\dashv \vdash \!\!\!\!-$ | totype Approva          |          |
| Date:                | 8-1-9         | Date:            | 08666    | 7                         | Date                    | e: N/A   |

| Measured by: | B     | Audited by: |         | Prototype Approval: | N/A |
|--------------|-------|-------------|---------|---------------------|-----|
| Date:        | 8-1-9 | Date:       | 08/01/9 | Date:               | N/A |
|              |       |             |         | \ <u></u>           |     |

| Rev | Date     | Change    | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| Α   | 07.06.13 | New Issue | KJ/JLM 🚜   | R        |

B. 52.12



**D3536-11 GASKET** 



1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

2) FINISH: NONE

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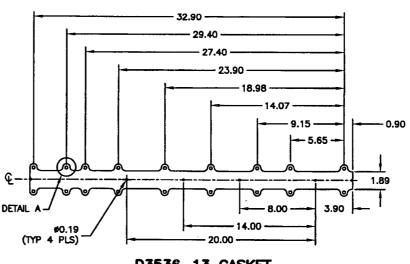
PURPOSE

유 COPIED

3) PART IS SYMMETRICAL ABOUT &
4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

7) SEE PAGE 6 FOR DETAILS AND SECTION



| D3536-13 | <u> </u> | ASKI | Ξ. |
|----------|----------|------|----|
|          |          |      |    |

| NEW ISSUE                | 06.10.25    | >        |   |
|--------------------------|-------------|----------|---|
| GASKET 1:10              |             | 06.10.25 | L |
| TITLE SCALE              |             | DATE     |   |
| D3536 SHEET 1 OF 6       | #           | M        |   |
| DRAWING NO. REV. A       | APPROVED // | CHECKED  | _ |
| DART AEROSPACE USA, INC. | DRAWN BY    | CB<br>CB |   |

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06.10.25

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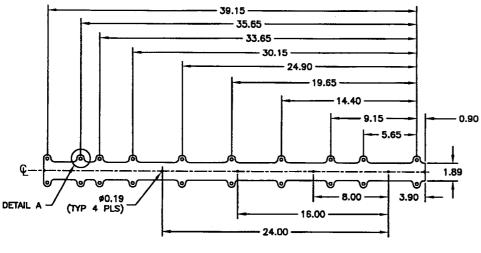
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D3536-15 GASKET

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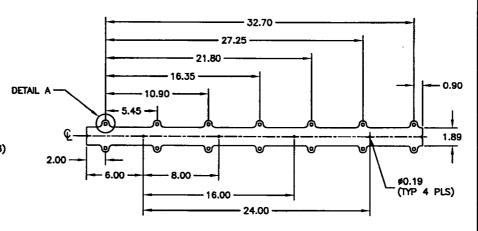
PURPOSE

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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE
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  4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  5) ALL DIMENSIONS ARE IN INCHES
  6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

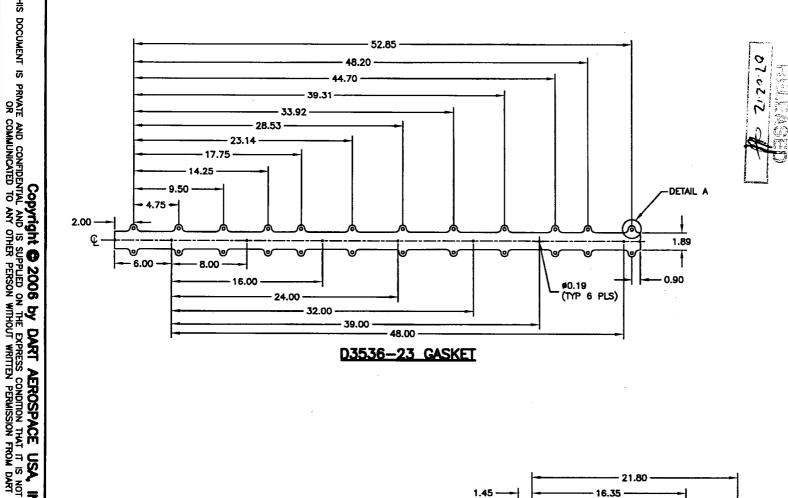


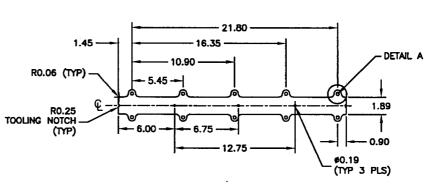
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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE
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D3536-25 GASKET

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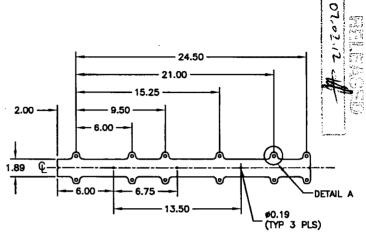
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22.50 2.00 -6.00 --1.89 DETAIL A 6.00 ≠0.19 (TYP 3 PLS)

D3536-31 GASKET



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PURPOSE

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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE 3) PART IS SYMM
- PART IS SYMMETRICAL ABOUT &
  TOLERANCES ARE PER DART QSI 018 UNLESS
  OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
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  PERMANENT INK MARKER
- DETAILS AND SECTION

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| D3536 SHEET 4 OF 6       | 717        |
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| DART AEROSPACE USA, INC. | CB         |

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DRAWING NO.

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AEROSPACE PORT HADLOCK,

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30.75 22.50 17.75 2.00 Ę 1.89 6.00 16.00 DETAIL A 21.00 #0.19 (TYP 4 PLS) D3536-37 GASKET

1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

35.71 32.78 29.28 25.78 23.25 19.75 2.00 -4.75 1.88 ≠0.19 (TYP 3 PLS) -- 5.00 DETAIL A 9.00 28.00 D3536-39 GASKET

Copyright © 2006 by DART AEROSPACE PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FR 1: BLACK NEOPRENE SHEL.
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OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
7) SEE PAGE 6 FOR DETAILS AND SECTION

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| TITLE SCALE        |             | DATE     |  |
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**DETAIL A** 

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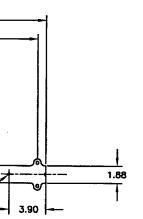
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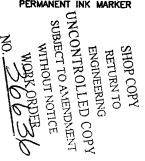
**DETAIL** 

MOTES

1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60
DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE 3) PART IS SYMM
- TOTAL
   TOTAL

5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER



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